

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/22
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:36:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 30302

Part Number: D29681

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

16 07/02/20 (40)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

7/2/20 (40)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

17 07/02/22

Job Completion



18 07/02/22

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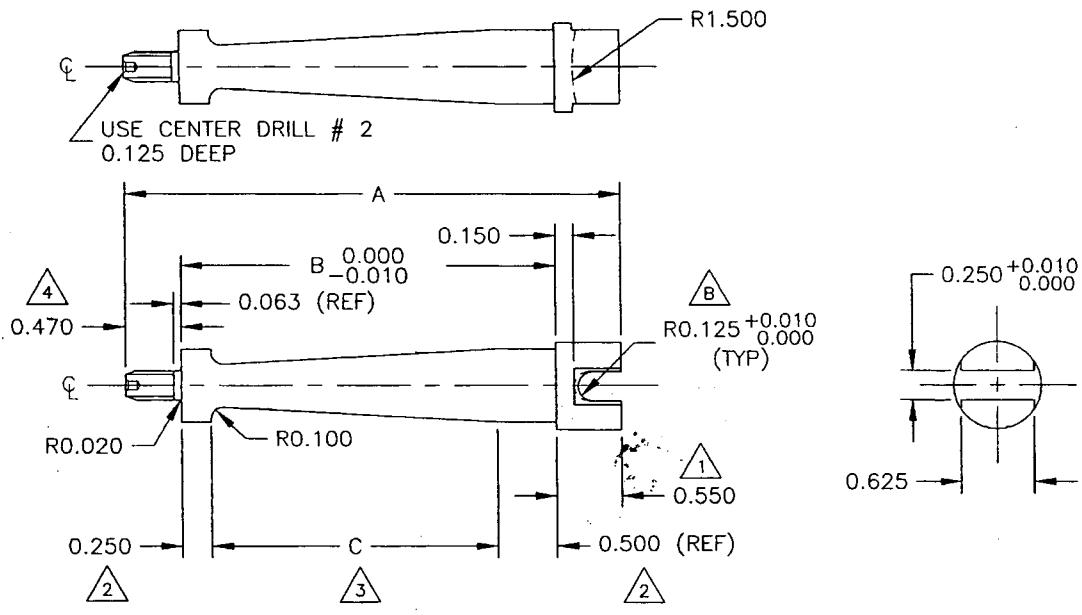
DART AEROSPACE LTD	Work Order:	30302
Description: Stem	Part Number:	D2968-1
Inspection Dwg: D2968	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>gml</u>	Audited by: <u>/SA</u>	Prototype Approval: N/A
Date: <u>07.02.14 07.02.15</u>	Date: <u>07.02.15</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D2968-041	KJ/RF	
B	05.05.26	Dimensions added	KJ/JLM	<i>[Signature]</i>



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

1 Ø0.750 O.D.

2 \varnothing 0,625 O.D.

**3) MACHINE UNIFORM TAPER FROM Ø0.363 O.D.
TO Ø0.625 O.D.**

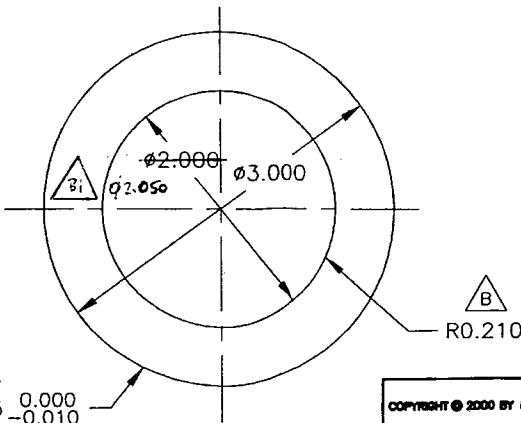
⚠ 1/4-28 UNF THREAD WITH 0.063 GRIP
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

D2968-5 RING:
MATERIAL: AISI 4130

MATERIAL AISI 4130
TOLERANCES ARE PER

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING

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DART AEROSPACE LTD.

D2968-041 AND D2968-043 TOW RING:
WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
FINISH: CAD PLATE ENTIRE ASSEMBLY PER
QQ-P-416F CLASS I TYPE II
POWDER COAT WHITE (REF 4.3.5.2) PER DART
QSI 005 4.3 (EXCEPT THREADS)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°		
A	00.03.07	NEW ISSUE		
DESIGN RF	DRAWN BY RF	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	
CHECKED RF	APPROVED RF	DRAWING NO. D2968	REV. B SHEET 1 OF 1	
DATE 00.05.31	TITLE TOW RING		SCALE 1:1	

NO.	RETURN TO	
	ENGINEERING	
NO. <u>30302</u>	IN CONTROLLED COPY	SUBJECT TO AMENDMENT
	WITHOUT NOTICE	WORK ORDER